

Work Order ID 84560

May-16-12 10:54:02 AM

84560

Page 1

Item ID: D212-722-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Avionics Console

Start Date: 5/16/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/16/12 Req'd Qty: 2.00

2

Customer:

Reference: rework-ECN11-587

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3363	Rev C

100 DOCUMENT CONTROL 0.00

100

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D212-722-011 CHG003

160 Pick Kit 0.00

160

Packaging

Memo

Packaging

PULL FROM HK TO UPDATE TO CHG003:
2 X D212-722-011 B37737

ADD TO EACH KIT
1 X D212-722-013 B

84561

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PN	D212-722-011	CHG	CHG002
DESC.	Avionics Console	STC	SH05-11
LOT	B37738	STC	SR02091NY
MODEL	Bell 204/205/212/214/412	STC	
MADE IN CANADA		02729-1	

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
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Work Order ID 84560

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Page 2

May-16-12 10:54:02 AM

Item ID: D212-722-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Avionics Console
 Start Date: 5/16/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/16/12 Req'd Qty: 2.00 *2* Customer:
 Reference: rework-ECN11-587

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING BEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D212-722-011								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/6/8
 MJS 12/10/07

Picklist Print

May-16-12 10:54:02 AM

Page 1

Work Order ID: 84560

Parent Item: D212-722-011

Parent Item Name: Avionics Console

Start Date: 5/16/12

Required Date: 5/16/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B05.04.11Now made at DartKJ/JLM
IPP Rev:C 07-06-09 Holes now Transfer drilled JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

S
D
D212-722-011
Avionics Console

Manufactured No

Each 5.0000

2

3377738 S

Location

Loc Qty

Loc Code

FG030

5

71097

1

71098

4

S
D
D212-722-013
Dzus Rail Brace

Manufactured No

Each 0.0000

2

384561 S
5/16/12

Change Record

Part Number D212-722-011

Page 1 of 1Description AVIONICS CONSOLE[illegible]

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 11.05.31	Job No.:	ADR Yes/No: N	ADR Date: 11.06.01	ECN #: 11- 587
Product No.: D212-722		Created By: HS	Approved By: HS	
Product Name: Avionics Riser Panel		Checked By: HS	General Manager Approval: N/A	

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL	CMF 11-06-16	DQA / QA Coord.	N		
Purchasing Coord.	N			QC Coordinator	N		
Production Engineering Coord.	Y	EC	B 11.06.16	Customer Technical Support	Y	MB	11.06.16
				Marketing	Y	SW	11.06.16
				Customer Order Processing	N		

Reason for Change:
Add D212-722-013 Dzus Rail Brace Kit

Documents Affected:
DSI 9476 Rev. A
D3986 Rev. A
MDL-D212-722 Rev. A

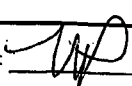
PARTS MUST COMPLY ☒ **PREVIOUS PARTS SATISFACTORY** ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	HS	MDL-D212-722 Rev. A	HS 11.06.01
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		11.06.2008
11	Update Product Specification Files	Y	KJ		11.06.16
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		11.06.16
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	Y	KJ		11.06.16
17	Update / Verify ARC Database	Y	KJ	# 92	11.06.16
18	Create / Update Change Record Form / Item Card Database	Y	KJ	D212-722-013 at CHG 001, D212-722-011 at CHG 003	11.06.16
19	Create / Update PPP's	Y	KJ		11.06.16
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		11.06.16
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		11.06.16
24					

Description / Action:
- create routes and BOM's for D212-722-013, D3986-1 and D3986-3
- add D212-722-013 to all D212-722-011 in stock

ECN Verified & Complete: 

Date: 11/10/08

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-722 REV. A

REF. TCCA STC: SH05-11
REF. FAA STC: SR02091NY
REF. EASA.IM.R.S.01181

The purpose of the Service Instruction is to provide instructions for the installation of the D212-722-013 Dzus Rail Brace Kit which has been developed to provide a fastening method for the center dzus rail when the D212-722-011 Avionics Riser Console is installed. The D212-722-013 kit has been added to all D212-722-011 kits at CHG 003 or later.

If the aircraft pedestal has been removed from the aircraft follow the instructions in Option 1. If the pedestal has not been removed from the aircraft follow instructions in Option 2 (Sheet 2).

The maximum weight of equipment installed in front of the D212-722-011 Avionics Riser Console using the D212-722-013 Kit is 40 lbs.

Option 1 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to the correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the existing center PR35 dzus rails.
- 2) Remove the existing center dzus rail braces.
- 3) Clamp the D3986-1 angle, D3986-3 braces and PR35 dzus rail together as shown in Figure 1 (Sheet 3). The D3986-3 braces should be approximately centered between the existing dzus rails.
- 4) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 5) Transfer drill 9x $\varnothing 0.129$ (#30 drill) holes from PR35 dzus rail thru D3986-3 braces. See Figure 2, (Sheet 4), Note 1.
- 6) Deburr holes and reassemble using clecos.
- 7) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 2, (Sheet 4), Note 2.
- 8) Deburr holes and reassemble using clecos.
- 9) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from aircraft pedestal to D3986-3 braces. See Figure 2, (Sheet 4), Note 3.
- 10) Deburr holes, dimple D3986-3 brace and aircraft pedestal and reassemble using clecos.
- 11) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft pedestal. See Figure 2, (Sheet 4), Note 4.
- 12) Deburr holes, dimple D3986-1 angle and aircraft pedestal and reassemble using clecos.
- 13) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails.
- 14) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 2 (Sheet 4) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

A	NEW ISSUE		11.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	11.06.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A DSI 9476 SHEET 1 OF 7	
DRAWING NO.		SCALE	
TITLE DZUS RAIL BRACE KIT		NTS	
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Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.






PARTS LIST

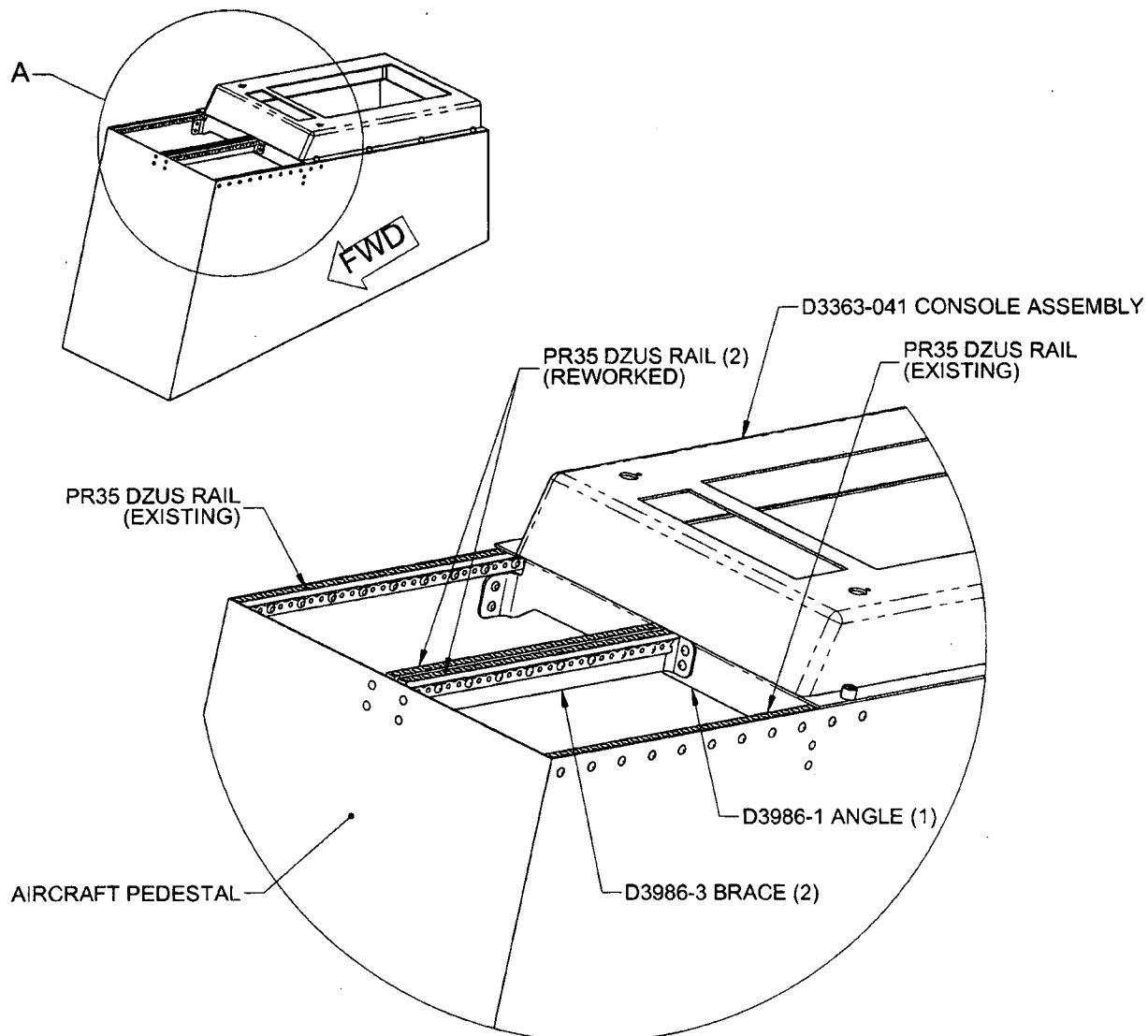
QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

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DEPARTMENT OF TRANSPORT
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BRANCH
DAO # 01-O-01

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DETAIL A

FIGURE 1: D212-722-013 DZUS RAIL BRACE INSTALLATION

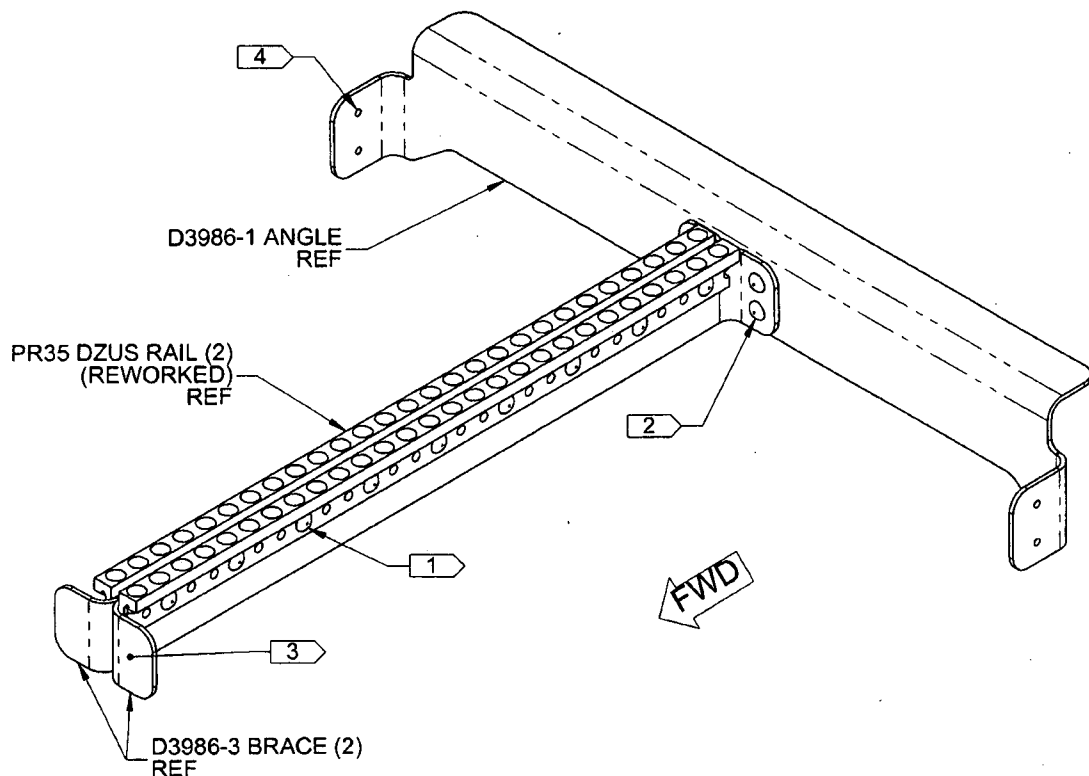
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- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM AIRCRAFT CONSOLE TO D3986-3 BRACES. DIMPLE D3986-3 BRACES AND INSTALL MS20426AD4 RIVETS, 4 PL.
- 4) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

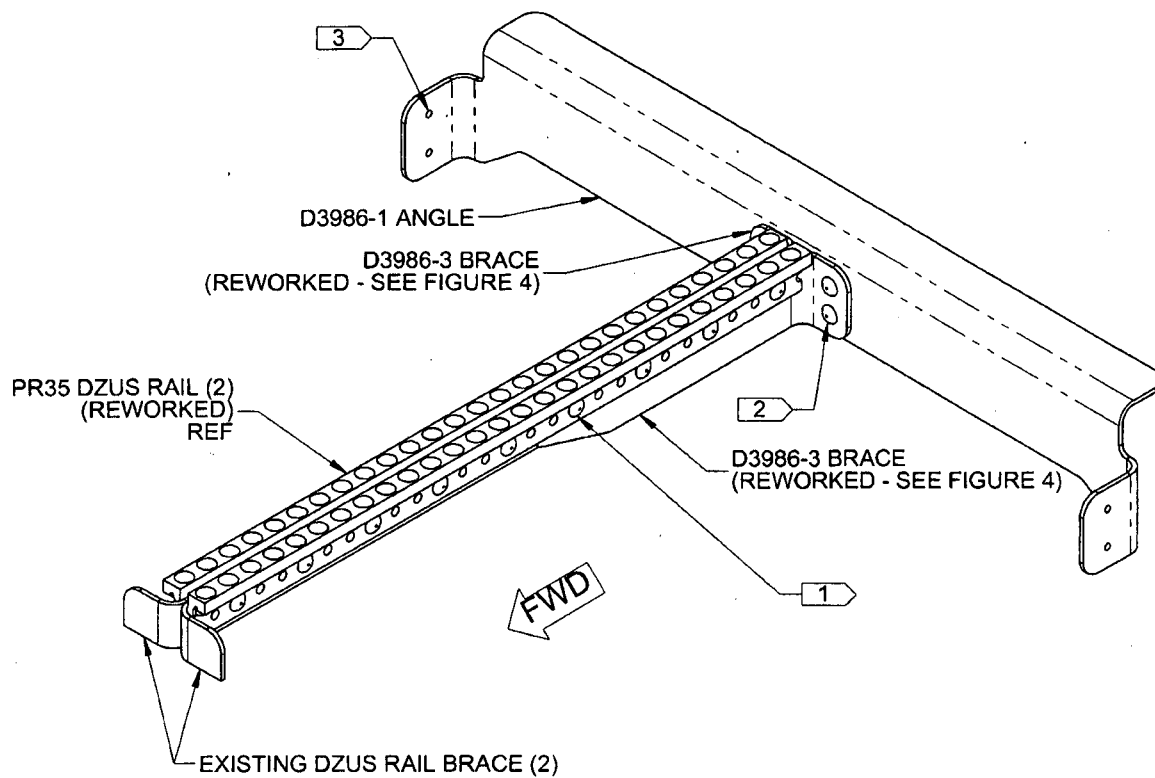
FIGURE 2: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 1
(PEDESTAL REMOVED FROM AIRCRAFT)

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- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL (4 PL TYP) $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL






FIGURE 3: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 2
(PEDESTAL NOT REMOVED FROM AIRCRAFT)

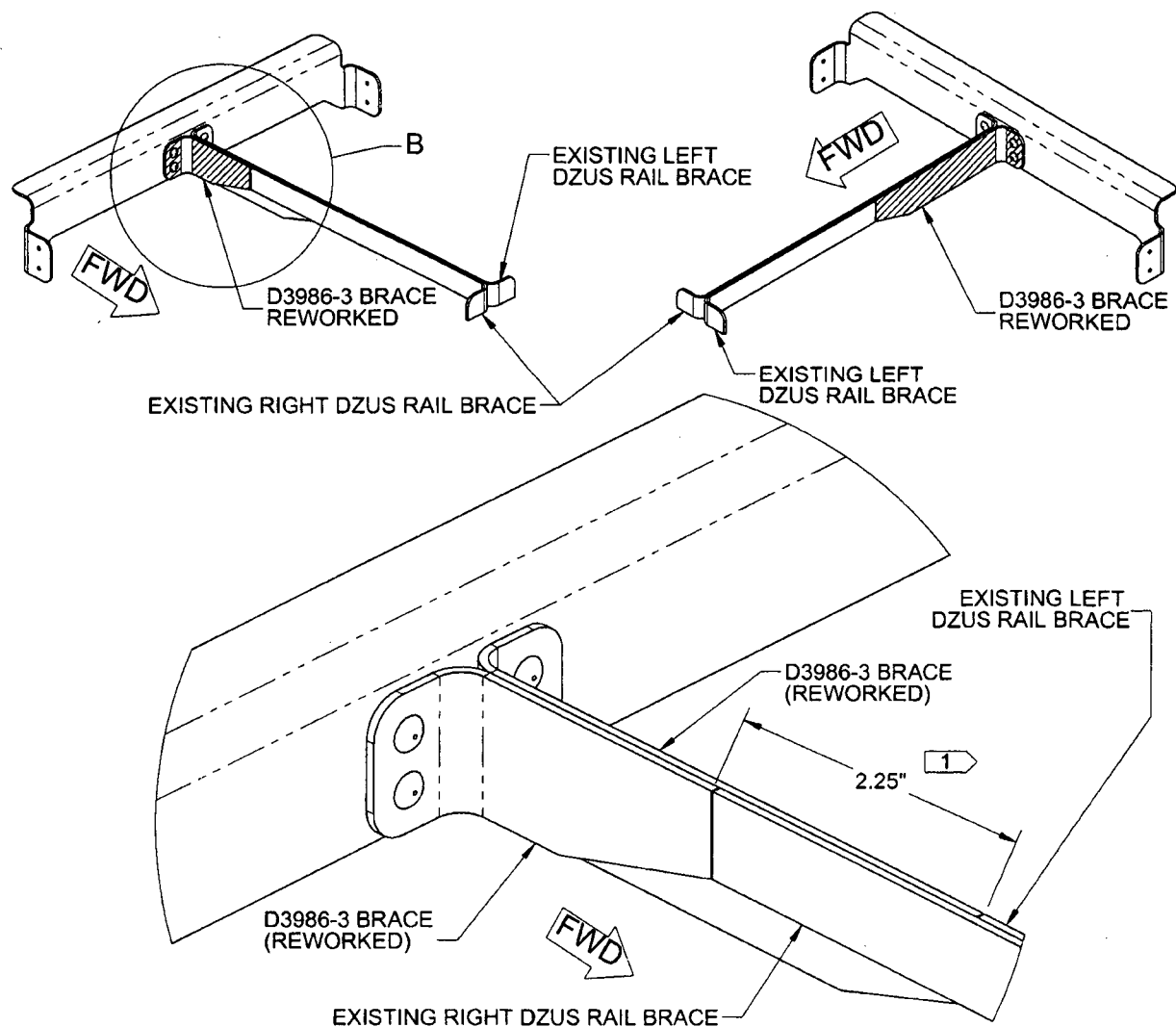
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DETAIL B

- 1) TRIM EXISTING LEFT DZUS RAIL BRACE SO THAT THE END IS HALF WAY BETWEEN EXISTING RIVET HOLES. TRIM EXISTING RIGHT DZUS RAIL BRACE 2.25" LONGER






FIGURE 4: EXISTING DZUS RAIL BRACE TRIMMING DETAIL - OPTION 2
(REWORKED DZUS RAILS AND RIVETS NOT SHOWN FOR CLARITY)

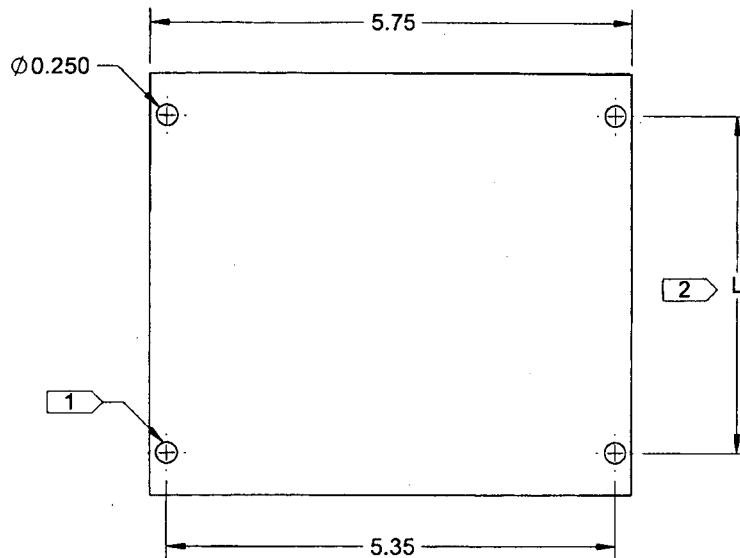
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- 1) INSTALL DZUS FASTENERS, 4 PL TYP
- 2) DIMENSION "L" IS MIN 4". MUST BE DIVISIBLE BY 0.375

FIGURE 5: BLANKING PLATE

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